

# Work Order ID 62479




Thursday, September 30, 2010 2:21:08 PM






Page 1

Item ID: D2154 Accept  Setup Start   
Revision ID: Stop   
Item Name: Stud Bracket  
Start Date: 9/30/2010 Start Qty: 10.00  Cust Item ID:  
Required Date: 10/8/2010 Req'd Qty: 10.00  Customer:

## Reference:

Approvals: Process Plan:  Date: 10-9-30 Tooling: Date: Run Start   
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2154	Rev C								
100	FLOW WATER JET	0.00							
 Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2154 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary								
<del>6051-063</del> 304. 063									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
 QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
 QC	Memo	0.00							
Quality Control									

MAY NOT PULLED

FB 10-10-5

(11)

Pho →

FB 10-10-5

8/10/10/13

(XIC)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2154 PAR #: \_\_\_\_\_ Fault Category: Prod Eng - Control NCR: Yes No DQA: \_\_\_\_\_ Date: 10/10/05  
 Resolution: Documentation Scrap Revision Disposition: Scrap QA: N/C Closed HJ Date: 10/10/25

NCR: <u>62479</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/10/05</u>	<u>#100</u>	Found at inspection that Qty x11 (all) parts were made with the incorrect mat. Parts were made	<u>/BS1042</u>	→ Fix mat. on w/o b call us for correct 304 As per Drawing ADD copy of correct BOM for Ref.			<u>/BS1042</u>	<u>S</u> <u>10/10/05</u>
		with 6061 and Drawing call for 304 stainless. R.C. wrong mat called up on w/o. + operators	<u>/BS1042</u>	→ SCRAP + Replace Qty x11 with correct mat. M <u>115668 304 .063"</u>	<u>BS1042</u> <u>x11</u>	<u>S</u> <u>10/10/13</u>	<u>/BS1042</u>	<u>S</u> <u>10/10/05</u>
		Defect check with Dwg. R.C. LOM	<u>/BS1042</u>	+ Part w/o's were verified & were cut using the correct material. Also no PTO was written up for material change & I PP Rev's match old w/o's.			<u>/BS1042</u>	<u>/</u> <u>10/10/05</u>

NOTE: Date &amp; initial all entries



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries




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Item ID:	D2154	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Stud Bracket					
Start Date:	9/30/2010	Start Qty:	10.00		Cust Item ID:	
Required Date:	10/8/2010	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M115291</i> Memo START TIME: <i>10:40</i> <i>400°</i> <input type="checkbox"/> FINISH TIME: <i>11:10</i>	0.00 <i>BK 10-10-21.</i> 0.00				<i>11</i>			
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 <i>=&gt; 11 10/10/21</i> 0.00				<i>11</i>	<i>0</i>		
180  Packaging Packaging	Identify as per dwg & Stock Location: <i>7</i>  Memo	0.00 0.00				<i>10/10/21 21 (114)</i>			

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 62479**

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Item ID: D2154

Accept

Revision ID:

Item Name: Stud Bracket

Start Date: 9/30/2010 Start Qty: 10.00

Required Date: 10/8/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/25

MF

10-10-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, September 30, 2010 2:21:12 PM

Page 1

Work Order ID: 62479



Parent Item: D2154



Parent Item Name: Stud Bracket

Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C03.08.08 Reformat; Remove Tumble KJ/RF  
IPP Rev:D NowOn Waterjet 07-04-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

82.2840

9.08

1.5



6061-T6 .063 Sheet

B10-10-5

Location

Loc Qty

Loc Code

MAT21

82.284

113608

82.284

115688

~~115688~~

115668

(11)

304 .063

m304S169A

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

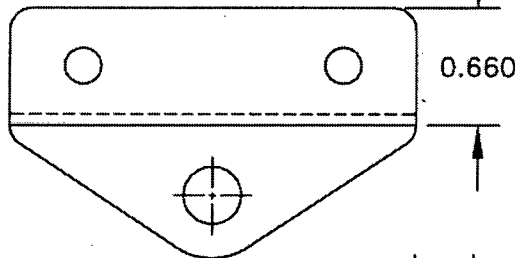
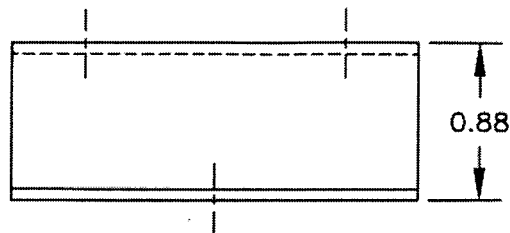
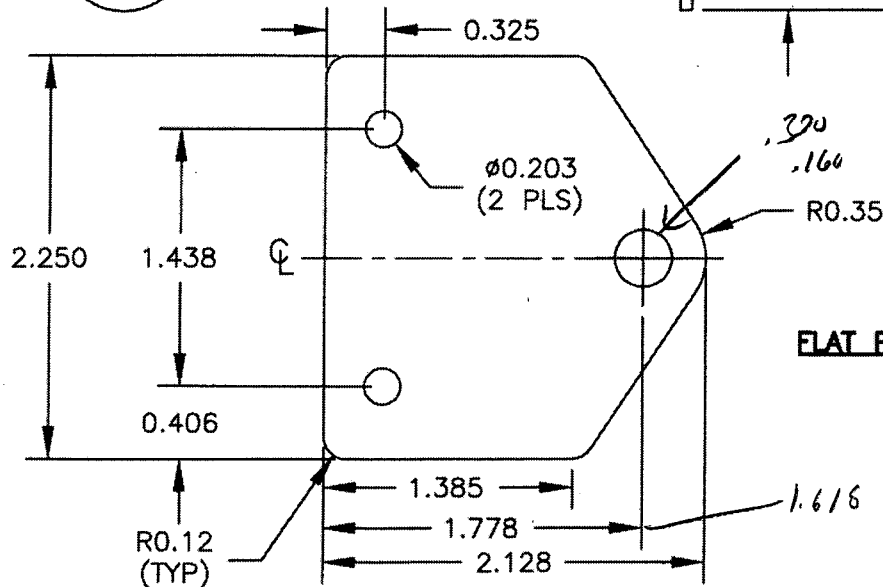
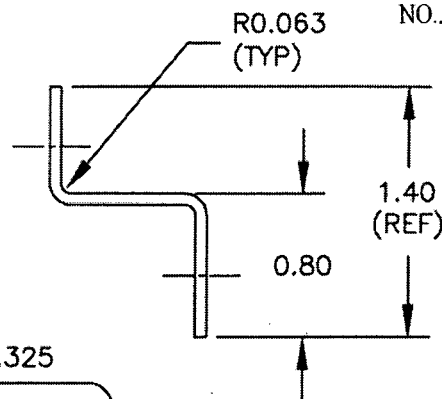
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**DART**

DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154	REV. C SHEET 1 OF 1
DATE 04.10.12	TITLE BRACKET, STUD		SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

RELEASED  
04.10.15 *[Signature]*

**BEND DETAIL****FLAT PATTERN****D2154 NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

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